

Work Order ID 134799

Monday, July 20, 2015 1:34:21 PM

134799

Page 1

Item ID: D119-675-012

Revision ID:

Item Name: Heli-Access-Step™ RH

Start Date: 7/20/15 Start Qty: 1.00 *1*

Required Date: 7/24/15 Req'd Qty: 1.00 *1*

Reference: REWORK USED FOR TESTING

Approvals: Process Plan: [Signature] Date: 15-7-20 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

PATENT		N/A	
PN	D119-675-012	CHG	CHG005
DESC	Heli-Access-Step, RH	SIC	SR00948SE
LOT	B117292	SIC	
MODEL	Agusta A119/AW119MKII	SIC	
TC APPROVAL # 0939		MADE IN CANADA	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9647	A

J.A

110	Pick Kit	0.00
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110

Packaging

Packaging

Memo

PULL FROM STOCK
D119-675-012
B:117292

STEP WAS UDED FOR TESTING

CLEAN AND TOUCH UP AS REQUIRED
COMPLETE KIT FOR MISSING PARTS

120	QC4- 100% Inspect kits for completeness	0.00
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120

QC

Quality Control

Memo

AUG 21 2015

DAS
38
9-88

AUG 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Work Order ID 134799

134799

Page 2

Monday, July 20, 2015 1:34:21 PM

Item ID: D119-675-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ RH
 Start Date: 7/20/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/24/15 Req'd Qty: 1.00 *1* Customer:
 Reference: REWORK USED FOR TESTING

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-675-012 Location : FG081								
	<i>5820</i> *RE Package under New Batch Number								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ML5 AUG 21 2015

Stt 20150821

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Monday, July 20, 2015 1:34:26 PM

Page 1

Work Order ID: 134799

134799

Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step™ RH

Start Date: 7/20/15

Required Date: 7/24/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
 IPP Rev:E change to rev.b as per ECN1107 DD verified by: IPP REV:F
 13.09.03 chg005 / DSI9647 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-15A		Purchased	No				Each	335.0000		4			
AN4-15A									**				
Bolt	68-6 8C SVD									JA			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				GA				40					
				120449				40					
				ST325A				295					
				m128978				8					
				m132317				87		4			
				m132551				200					
AN4-16A		Purchased	No				Each	184.0000		8			
AN4-16A									**				
Bolt	DAS 38 9-89									JA		JUL 22 2015	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				FG				5					
				121541				5					
				ST343				179					
				M132317				179		8			
D119-675-012		Manufactured	No				Each	3.0000					
D119-675-012									**				
Heli-Access-Step™ RH	DAS 38 9-89									15.7.20			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>	117292			
				FG081				3					
				106482				1					
				125560				2					

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Monday, July 20, 2015 1:34:26 PM

Page 2

Work Order ID: 134799

134799

Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step™ RH

Start Date: 7/20/15

Required Date: 7/24/15

Start Qty: 1.00

Required Qty: 1.00

D2274

Manufactured No

Each

185.0000

8

D2274

Radius Block

DAS
38
9-89

Location

Loc Qty

Loc Code

FG

12

86855

12

ST

24

110264

24

ST006

149

127579

11

128474

3

131031

135

**

JA

D2617-3

Manufactured No

Each

38.0000

4

D2617-3

Bushing

DAS
38
9-89

Location

Loc Qty

Loc Code

FG

10

27991

10

ST008A

28

132912

28

**

JA

D2617-5

Manufactured No

Each

32.0000

4

D2617-5

Spacer

DAS
38
9-89

Location

Loc Qty

Loc Code

FG

10

31756

10

ST008A

10

134046

10

ST009

12

128826

12

**

JA

JUL 22 2015

Monday, July 20, 2015 1:34:26 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

Monday, July 20, 2015 1:34:26 PM

Page 3

Work Order ID: 134799

134799

Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step™ RH

Start Date: 7/20/15

Required Date: 7/24/15

Start Qty: 1.00

Required Qty: 1.00

D2732-032 Manufactured No

Each 19.0000 8

D2732-032

Rubber Cushion - 3.2"

DAS 15-07-22 DAS
9 38
9-89 9-89

8 X 3.2"

Location	Loc Qty	Loc Code
ST410	19	

**

JA

JUL 22 2015

D3041-1 Manufactured No

Each 42.0000 4

D3041-1

Clamp

DAS
38
9-89

Location	Loc Qty	Loc Code
117106	19	
ST410	19	

**

JA

D3041-3 Manufactured No

Each 32.0000 2

D3041-3

Clamp

DAS
38
9-89

Location	Loc Qty	Loc Code
ST520	8	
128623	8	
ST539A	34	
128623	34	

**

JA

D3041-5 Manufactured No

Each 42.0000 4

D3041-5

Clamp

DAS
38
9-89

Location	Loc Qty	Loc Code
ST520	32	
125823	6	
128620	26	

**

JA

JUL 21 2015

Monday, July 20, 2015 1:34:26 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

Monday, July 20, 2015 1:34:26 PM

Page 4

Work Order ID: 134799

Parent Item: D119-675-012

Parent Item Name: Heli-Access-Step™ RH

Batch ???
125562

2*

Start Date: 7/20/15

Required Date: 7/24/15

Start Qty: 1.00

Required Qty: 1.00

D3041-7

Manufacture
DAS
38
9-89

D3041-7

Clamp

Each 48.0000 2

**

J.A

JUL 21 2015



Location

Loc Qty

Loc Code

ST520

48

127367

20

128627

28

2

D3043-042

Manufactured No

D3043-042

Step Weldment RH

MS21042L4

Purchased No

Each 0.0000

**

1



MS21042L4

Locknut

DAS
38
9-89

Each 3,744.000 12

**

J.A

JUL 21 2015



Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

142

m127813

142

ST260a

3420

m129472

8

m130799

56

m131803

6

m132262

350

m132382

3000

12

ST305

180

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Page 5

Monday, July 20, 2015 1:34:26 PM

Work Order ID: 134799

134799

Parent Item: D119-675-012

D119-675-012

Parent Item Name: Heli-Access-Step™ RH

Start Date: 7/20/15

Required Date: 7/24/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

3,962.000

12

NAS1149D0463.J

J.A JUL 21 2015

WASHER

DAS
38
9-89

Location

Loc Qty

Loc Code

GA	53	
M129390	53	
ST260a	1000	
M132677	1000	
ST269	2909	
M129682	86	
M130799	371	
M132035	2295	
M132317	157	

12

Monday, July 20, 2015 1:34:26 PM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS				
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY						
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	Past Due ☐							

REFERENCE ONLY

4.0 WEIGHT AND BALANCE:

Use the following Weight and Balance for D119-675-011/-012 @ CHG 005 or later.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011	11.8 lb	-32.4 in	-382 in-lb	121.3 in	1431 in-lb
Heli-Access-Step™, LH	5.4 kg	-1.28 m	-6.9 m-kG	3.08 m	16.6 m-kG
D119-675-012	11.8 lb	+32.4 in	+382 in-lb	121.3 in	1431 in-lb
Heli-Access-Step™, RH	5.4 kg	+1.28 m	+6.9 m-kG	3.08 m	16.6 m-kG

5.0 PARTS LISTS:

QTY -011	Part Number	Description
X	DSI 9647-011	CLAMP REPLACEMENT KIT
4	D2732-032	RUBBER CUSHION
4	D3041-5	CLAMP
2	D3041-7	CLAMP
8	AN4-16A	BOLT
8	AN960JD416	WASHER
8	MS21042L4	BOLT

Use the following Parts List for D119-675-011/-012 @ CHG 005 or later.

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	HELI-ACCESS-STEP™, LH
	X	D119-675-012	HELI-ACCESS-STEP™, RH
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
4	4	D2617-5	BUSHING
8	8	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3041-5	CLAMP
2	2	D3041-7	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
8	8	AN4-16A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9647	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CLAMP REPLACEMENT	NTS
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